



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3506-3

Job Sheet 190648



Part No: D3506-3

Job Qty: 20 pcs

Part Name: Doubler



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/12/19

Job Tracking No:

Due Date: 3/8/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 06-05-31 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		3/8/19	0.00	0.71	Waterjet - Flow		19/02/16
110	QC 2	20 pcs		3/8/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		19/02/16
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

Plex 2/12/19 1:49 PM Dart.lajeunesse.marie

120 HAAS 4 Axis - B4B	20 pcs	3/8/19	0.00 1.43	QC 2 - 66	
				QC 2 - 64	
				HAAS - 1 - B4B	DIP 19-02-25
				HAAS - 2 - B4B	
				HAAS - 3 - B4B	
130 QC 2	20 pcs	3/8/19	0.00 0.00	HAAS - 4 - B4B	
				QC 2 - 1	
				QC 2 - 12	
				QC 2 - 14	
				QC 2 - 17	
				QC 2 - 19	
				QC 2 - 2	
				QC 2 - 20	
				QC 2 - 22	
				QC 2 - 23	# DIP 19-02-25
				QC 2 - 25	
				QC 2 - 32	
				QC 2 - 33	
				QC 2 - 35	
				QC 2 - 39	
				QC 2 - 4	
				QC 2 - 40	
				QC 2 - 44	
				QC 2 - 45	
				QC 2 - 48	
				QC 2 - 49	
				QC 2 - 50	
				QC 2 - 51	
				QC 2 - 52	
				QC 2 - 54	
				QC 2 - 56	
				QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
140 QC 8	20 pcs	3/8/19	0.00 0.00	QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	# 19-02-25
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 47	
150 Small Fab - 2 - B4B	20 pcs	3/8/19	0.00 0.23	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	

160 QC 5	20 pcs	3/8/19	0.00 0.00	Small Fab - 3 - B4B	DAS
				Small Fab - 4 - B4B	36
				Small Fab - 5 - B4B	9-89
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	DAS 40 9-89
				QC 5 - 50	
				QC 5 - 30	
170 Handfinish - 1-1 Chemical-B4B	20 pcs	3/8/19	0.00 0.34	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	D.R. 19/02/28
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
180 QC 7	20 pcs	3/8/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	

					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 6	
					QC 7 - 60	DAS
					QC 7 - 9	40
					QC 7 - 68	9-89
					QC 7 - 50	9-89
					QC 7 - 67	
190	Packaging 3-1 - Stock - B4B	20 pcs	3/8/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
200	QC 21 - SA	20 pcs	3/8/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	21
						9-89
						MAR 20 2019

QC 21 - SA - 53

Part Op **100** - 1-Cut as per Dwg D3506 Dwg Rev: B Prog Rev: B 2-Debur if necessary
 Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB
120 - (HAAS CNC Vertical Machine), Machine as per Folio FA640 and Dwg D3506
130 - QC2- Inspect parts off machine FAI/FAIB
140 - QC8- Inspect parts - second check
150 - C'sink as per Dwg D3506 (On Flat side)
160 - QC5- Inspect part completeness to step on W/O
170 - Chemical Conversion Coat per QSI005 4.1
180 - QC7-Inspect Chemical Conversion Coat
190 - Identify as per dwg & Stock Location: _____ LOCATION : LG001
200 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.100	6061-T6 .100 Sheet	.1560 sf (.0078 ea)	100-Waterjet - Flow - 1	<u>5025678</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.100	0	46	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Doubler	0.128inches + 0.005 - 0.001	0.133 0.127	<u>0.131</u>	<u>Vern.</u>
2	Doubler	0.277inches + 0.006 - 0.001	0.283 0.276	<u>0.278</u>	"
3	Doubler	0.750inches ± 0.010	0.760 0.740	<u>0.746</u>	"
4	Doubler	1.500inches ± 0.010	1.510 1.490	<u>1.500</u>	"
5	Doubler	0.375inches ± 0.010	0.385 0.365	<u>0.375</u>	"
6	Doubler	0.750inches ± 0.010	0.760 0.740	<u>0.750</u>	"
7	Doubler	0.250inches ± 0.010	0.260 0.240	<u>0.250</u>	"
8	Doubler	0.098inches ± 0.010	0.108 0.088	<u>0.097</u>	"

Audited by : DAS
20
9-89 19-02-25

Plex 2/12/19 1:49 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen Street
Cambridge, ON N6A 1K7
CANADA
TEL: 1-813-632-5200
Email: sales@dartaero.com
www.dartaero.com

Container No: S154442



Part: D3506-3

Job No: 190648

Serial No/Batch: S154442

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/18/19